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Liu et al.

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(54) **SEMICONDUCTOR STRUCTURE WITH METAL GATE AND METHOD OF FABRICATING THE SAME**

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See application file for complete search history.

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(*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 59 days.

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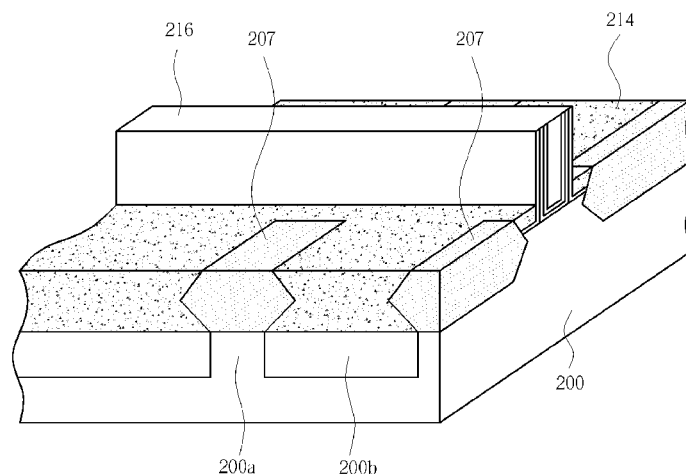
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(57) **ABSTRACT**

A metal gate process comprises the steps of providing a substrate, forming a dummy gate on said substrate, forming dummy spacers on at least one of the surrounding sidewalls of said dummy gate, forming a source and a drain respectively in said substrate at both sides of said dummy gate, performing a replacement metal gate process to replace said dummy gate with a metal gate, removing said dummy spacers, and forming low-K spacers to replace said dummy spacers.

6 Claims, 9 Drawing Sheets



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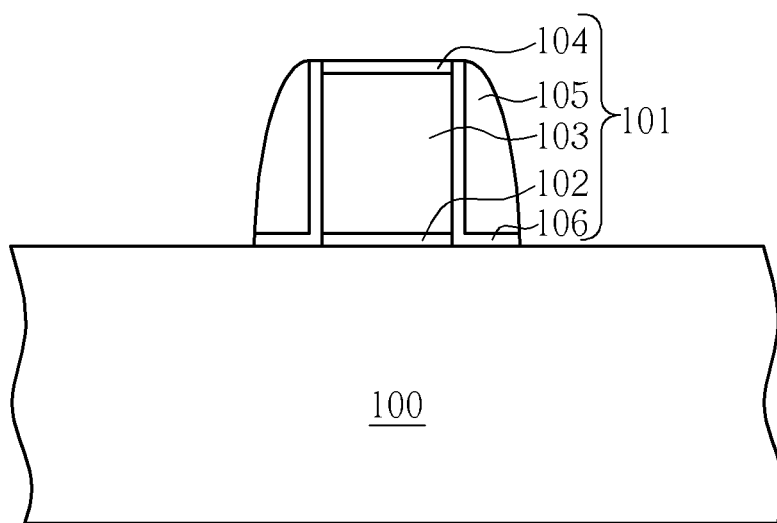


FIG. 1

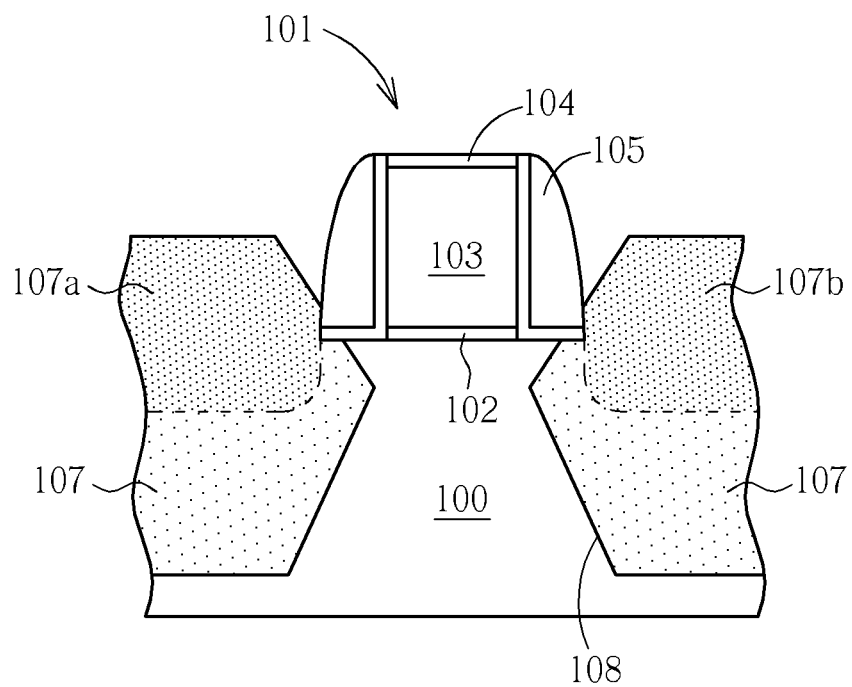


FIG. 2

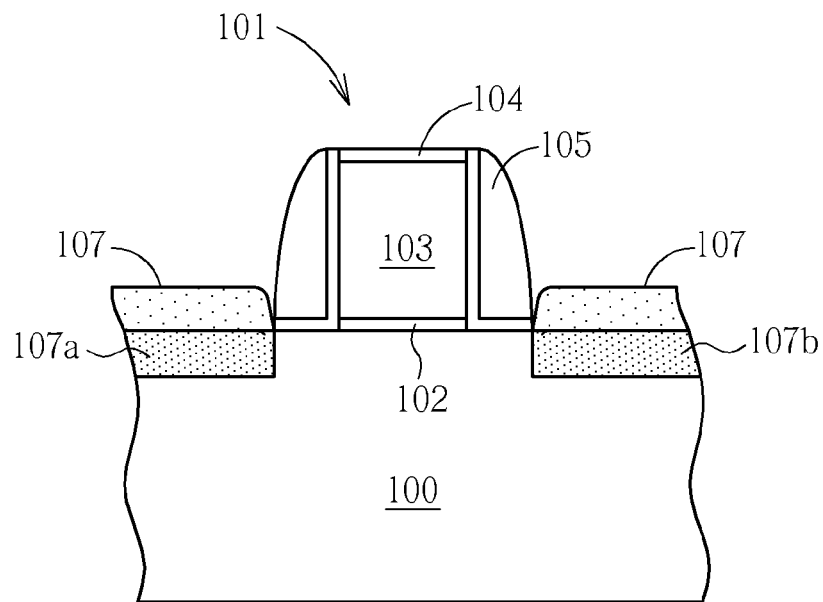


FIG. 3

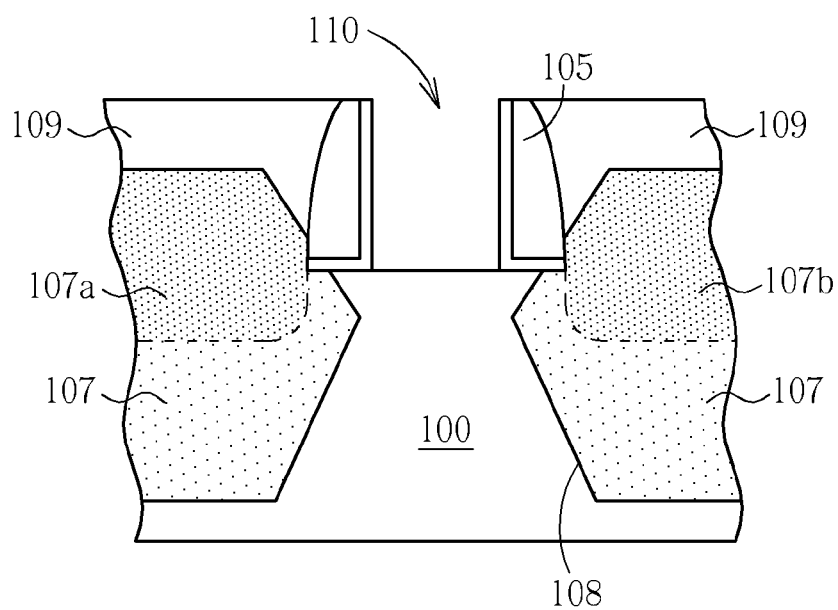


FIG. 4

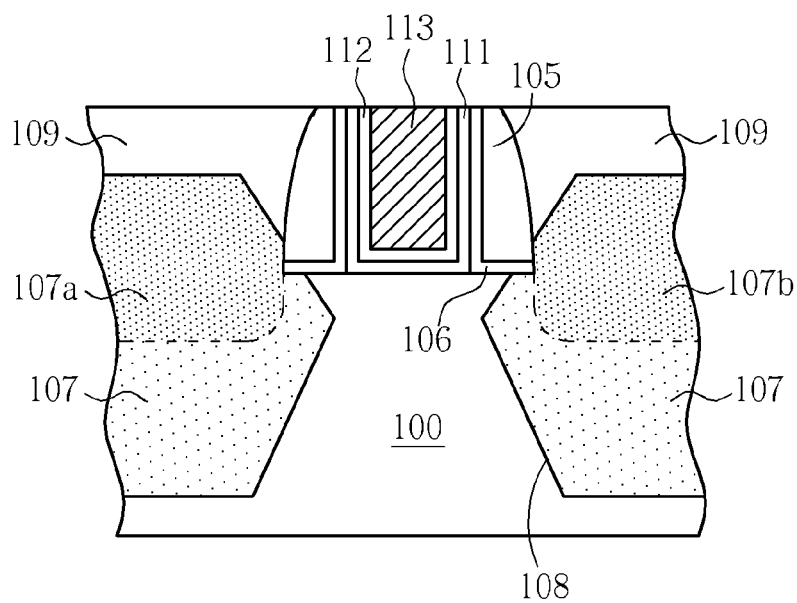


FIG. 5

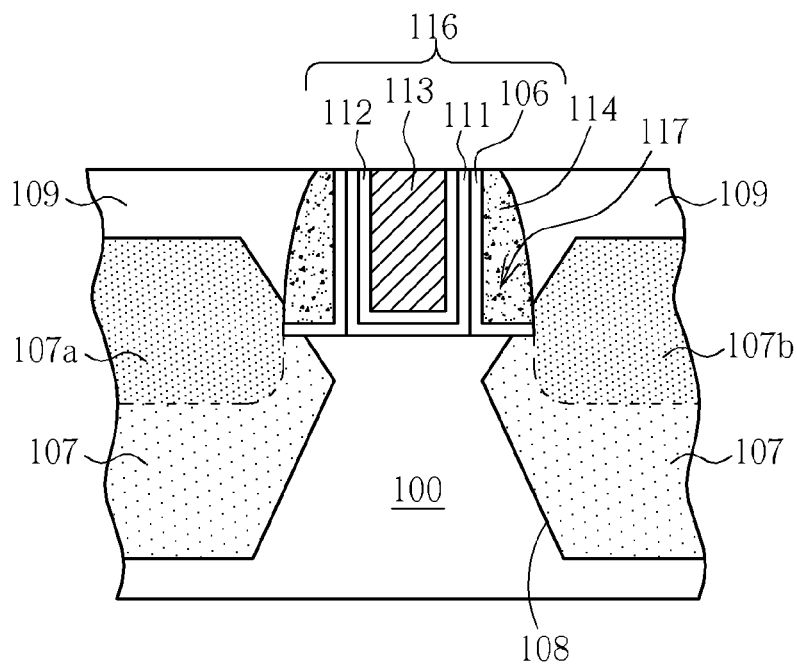


FIG. 6

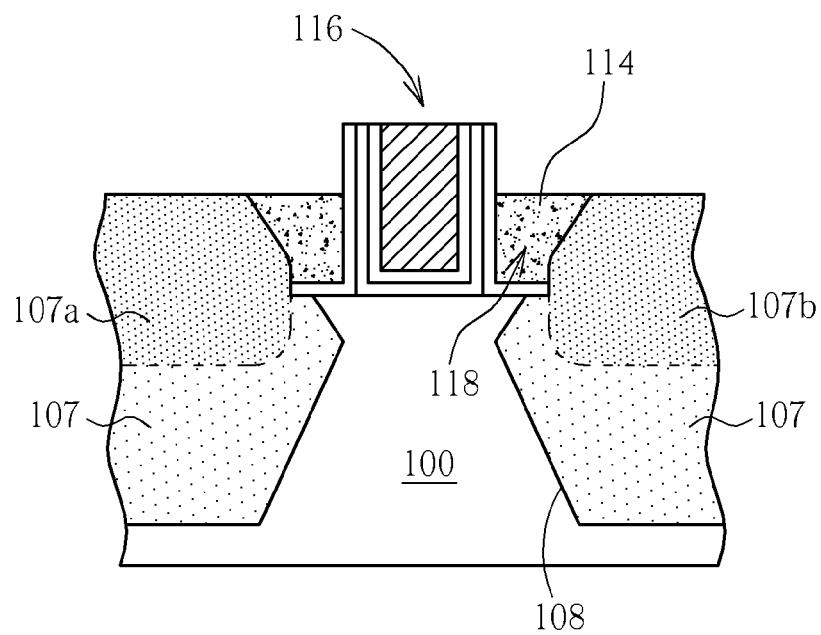


FIG. 7

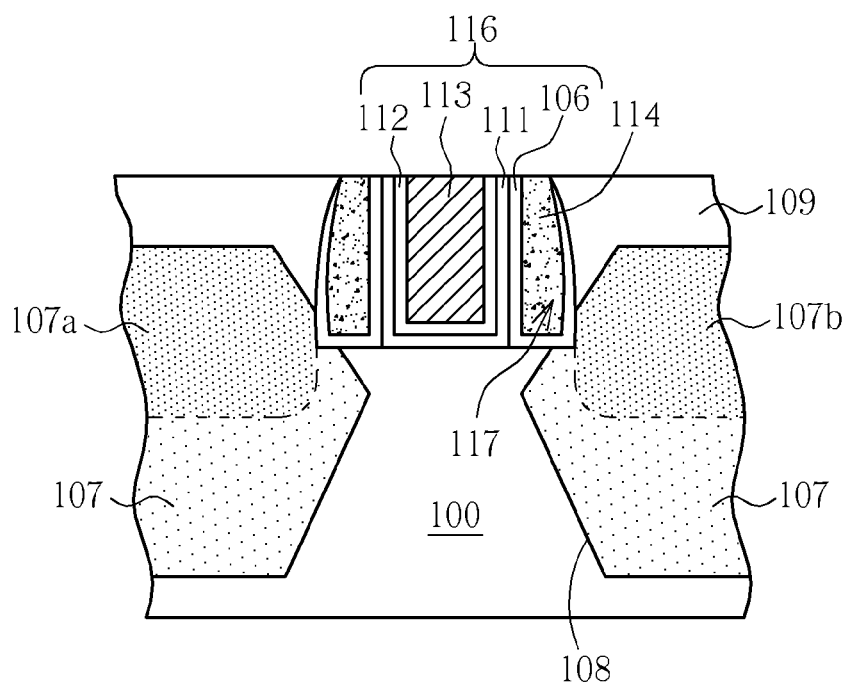


FIG. 8

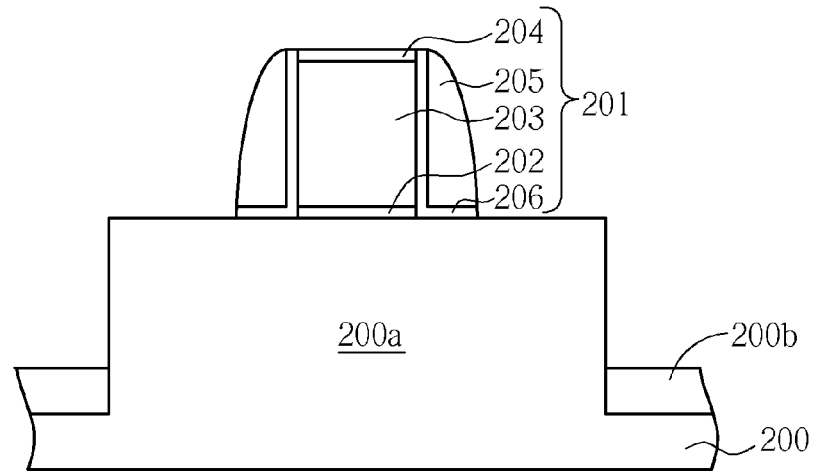


FIG. 9

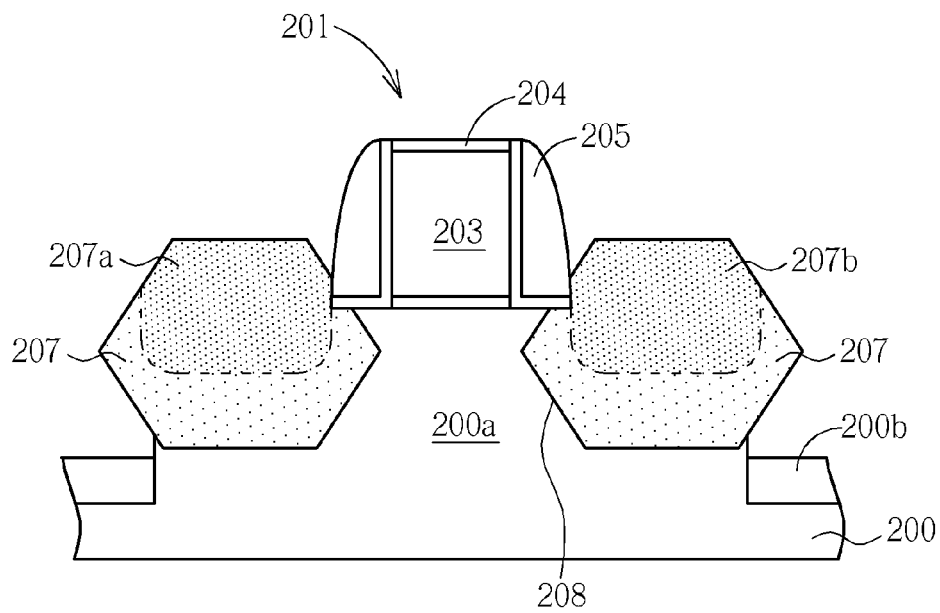


FIG. 10

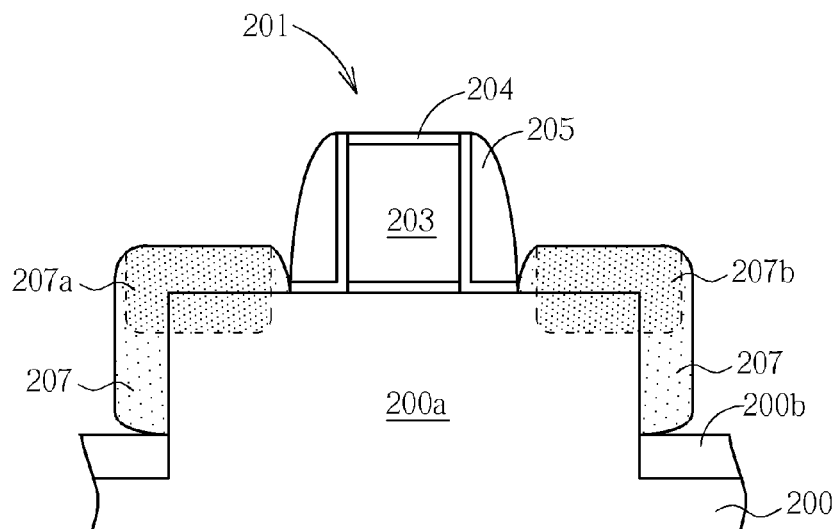


FIG. 11

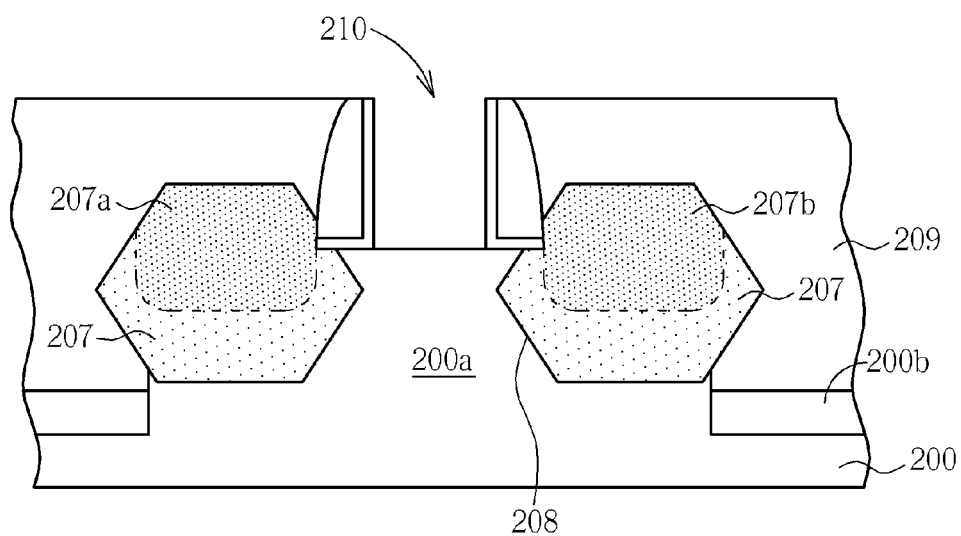


FIG. 12

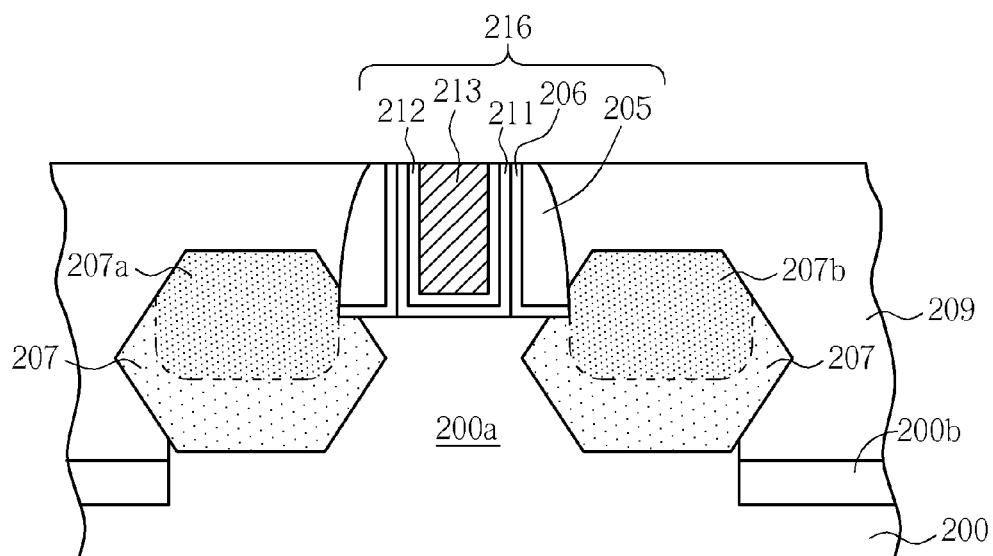


FIG. 13

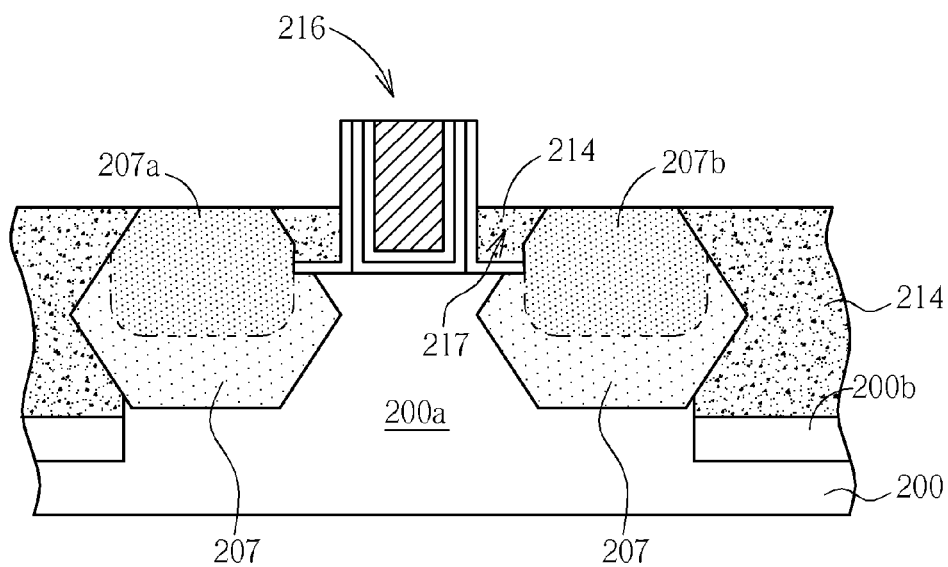


FIG. 14

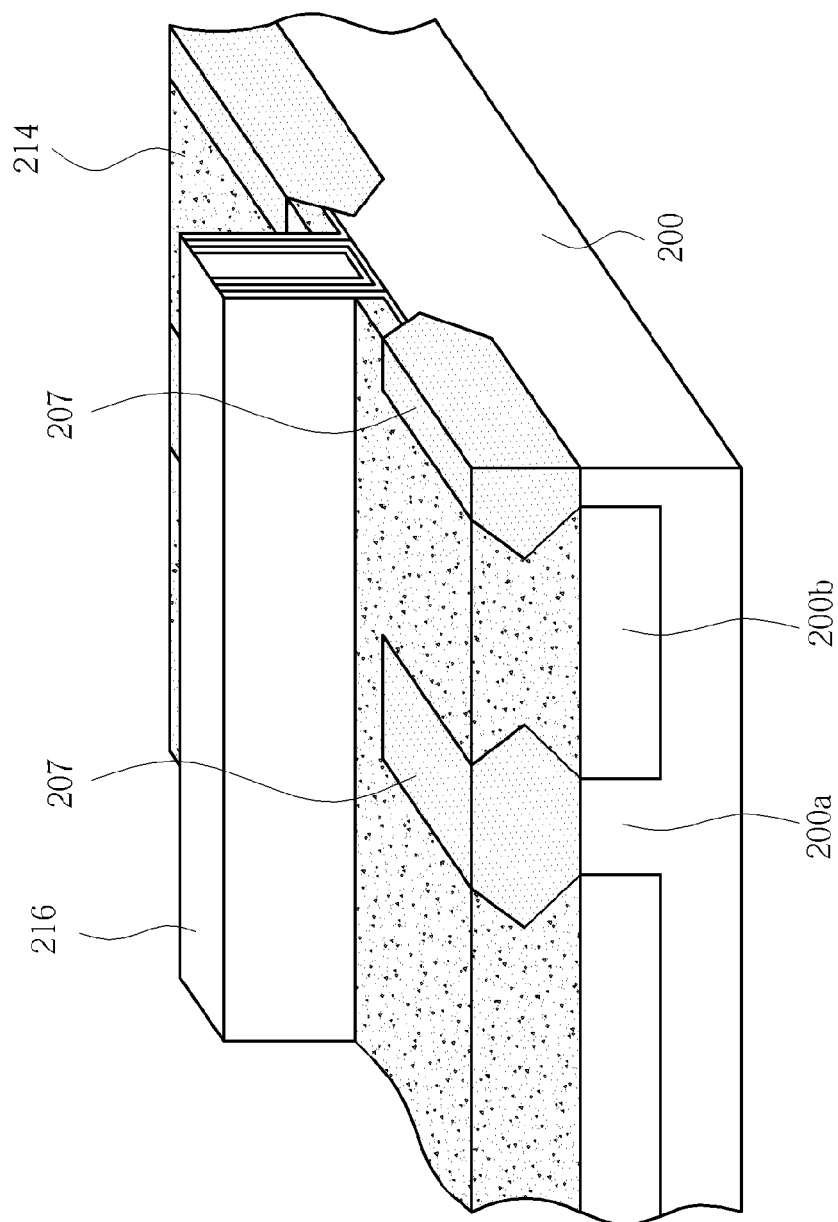


FIG. 15

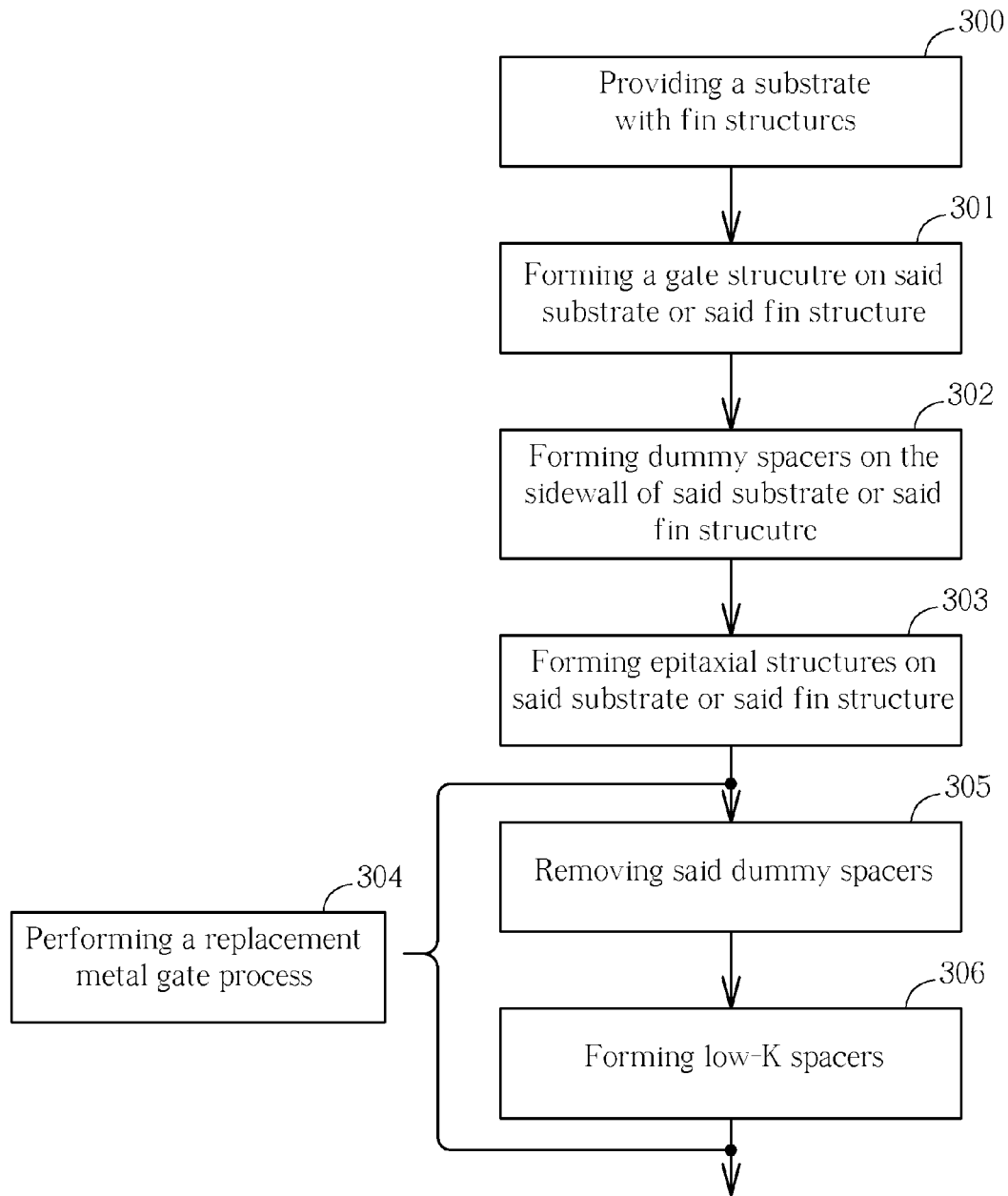


FIG. 16

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SEMICONDUCTOR STRUCTURE WITH METAL GATE AND METHOD OF FABRICATING THE SAME

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention relates generally to a semiconductor structure and a method of fabricating the same. In particular, the present invention relates to a semiconductor structure with metal gate and low-K spacer and a method of fabricating the same.

2. Description of the Prior Art

In recent years, as various kinds of consumer electronic products have continuously improved and been miniaturized, the size of semiconductor components has reduced accordingly, in order to meet requirements of high integration, high performance, and low power consumption.

With the trend in the industry being towards scaling down the size of the metal oxide semiconductor transistors (MOS), three-dimensional or non-planar transistor technology, such as fin field effect transistor technology (Fin FET) has been developed to replace planar MOS transistors. The three-dimensional structure of a fin FET increases the overlapping area between the gate and the fin structure of the silicon substrate, the channel region can therefore be more effectively controlled. This way, the drain-induced barrier lowering (DIBL) effect and the short channel effect are reduced. The channel region is also longer for an equivalent gate length, thus the current between the source and the drain is increased. In addition, the threshold voltage of the fin FET can be controlled by adjusting the work function of the gate.

In conventional processes for fabricating fin FET devices, the sidewalls of the gate and fin structures are covered with a spacer. The material of said spacer tends to remain on the sidewalls of the fin structure, and the poor gap filling capacity makes it hard to fill the recess or the trench structure during the formation of said spacer. Furthermore, with the trend in the industry being towards scaling down the size of semiconductor devices, the distance between gate and source/drain becomes even smaller, thereby inducing parasitic capacitances. This may impact the electrical properties of the semiconductor devices.

Accordingly, the present invention is directed to improve the structure and process of conventional semiconductor devices, in order to further enhance the performance of the devices.

SUMMARY OF THE INVENTION

To overcome the above-mentioned drawbacks of the prior art, a new semiconductor structure and a method for fabricating the same is provided. The electrical properties of gate devices formed by this method are further improved by using the spacers made of low-K material to replace the preformed dummy spacer.

One objective of the present invention is to provide a metal gate process, comprising the steps of providing a substrate, forming a dummy gate on said substrate, forming a dummy spacer on at least one of the surrounding sidewalls of said dummy gate, forming a source and a drain respectively in said substrate at both sides of said dummy gate, performing a replacement metal gate process to replace said dummy gate with a metal gate; removing said dummy spacer, and forming a low-K spacer to replace said dummy spacer.

Another object of the present invention is to provide a fin field effect transistor (Fin FET) process comprising the step

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of providing a substrate, forming at least one fin structure on said substrates, forming a dummy gate on parts of said fin structure, forming a dummy spacer on at least one of the surrounding sidewalls of said dummy gate, forming a source and a drain respectively in said fin structure at both sides of said dummy gate, performing a replacement metal gate process to replace said dummy gate with a metal gate, removing said dummy spacer, and forming a low-K spacer to replace said dummy spacer.

Still another object of the present invention is to provide a semiconductor structure with a metal gate comprising a substrate, a metal gate on said substrate, epitaxial structures disposed respectively at both sides of said metal gate, and low-K spacers disposed respectively in the recesses between said metal gate and said epitaxial structures, wherein the top surface of said low-K spacer is lower than the top surface of said metal gate.

Still another object of the present invention is to provide a fin field effect transistor comprising a substrate, at least one fin structure formed on said substrate, a gate formed on said fin structure, epitaxial structures formed respectively in said fin structure at both sides of said gate, and low-K spacers formed respectively in the recesses between said gate and said epitaxial structures and in the recesses surrounding said fin structures, wherein said low-K spacer is leveled with the top surface of said epitaxial structure and lower than the top surface of said gate.

These and other objectives of the present invention will no doubt become obvious to those of ordinary skill in the art after reading the following detailed description of the preferred embodiment that is illustrated in the various figures and drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

The accompanying drawings are included to provide a further understanding of the embodiments, and are incorporated in and constitute apart of this specification. The drawings illustrate some of the embodiments and, together with the description, serve to explain their principles. In the drawings:

FIGS. 1-8 are cross-sectional views illustrating the process flow of a metal gate forming method in accordance with one preferred embodiment of the present invention;

FIGS. 9-15 are cross-sectional views illustrating the process flow of a fin field effect transistor (Fin FET) forming method in accordance with another embodiment of present invention; and

FIG. 16 is a process flow of present invention.

It should be noted that all the figures are diagrammatic. Relative dimensions and proportions of parts of the drawings have been shown exaggerated or reduced in size, for the sake of clarity and convenience in the drawings. The same reference signs are generally used to refer to corresponding or similar features in modified and different embodiments.

DETAILED DESCRIPTION

In the following detailed description of the invention, reference is made to the accompanying drawings which form a part hereof, and in which is shown, by way of illustration, specific embodiments in which the invention may be practiced. These embodiments are described in sufficient detail to enable those skilled in the art to practice the invention. Other embodiments may be utilized and structural, logical, and electrical changes may be made without departing from the scope of the present invention.

The embodiments will now be explained with reference to the accompanying drawings to provide a better understanding of the process of the present invention, wherein FIGS. 1-8 are cross-sectional views illustrating the process flow of a metal gate forming method in accordance with the first preferred embodiment of the present invention; FIGS. 9-15 are cross-sectional views illustrating the process flow of a fin field effect transistor (Fin FET) forming method in accordance with the second preferred embodiment of the present invention.

First, please refer to FIGS. 1-8. Those figures illustrate sequentially the process flow for fabricating a metal gate. First, as shown in FIG. 1, a substrate **100** is provided as the base of the whole semiconductor structure. The substrate **100** may be, but not limited to, a silicon substrate, an epitaxial silicon substrate, a silicon germanium (SiGe) substrate, a silicon carbide (SiC) substrate, or a silicon-on-insulator (SOI) substrate, etc. The substrate **100** may be provided with predetermined NMOS regions and PMOS regions and corresponding P-wells and N-wells. A patterned gate structure **101** is formed on substrate **100**, wherein the steps of forming gate structure **101** may comprise: forming sequentially a gate oxide layer (ex. SiO₂ and/or high-K material) **102**, a dummy gate **103** (ex. poly-Si, SiN, SiON, or advanced pattern film (APF)), and a cap layer **104** (ex. SiN or SiO₂). Subsequently, using lithography and etching process to pattern cap layer **104**, and then using patterned cap layer **104** as an etching hard mask to transfer the pattern of cap layer **104** to the gate oxide layer **102** and dummy gate **103**. The forming methods of gate structure **101** are well-known in the art, and are not described herein for simplicity.

Refer again to FIG. 1, the dummy spacer **105** is formed on at least one of the surrounding sidewalls of the gate structure **101**. The dummy spacer **105** is formed by depositing a material layer and then performing a dry etching process. In the present invention, the function of the dummy spacer **105** is to isolate the gate structure **101** from the epitaxial structure or the source/drain formed in subsequent processes. Also, the dummy spacer **105** has higher mechanical strength, which is better for the following replacement metal gate (RMG) process. The material of dummy spacer **105** may include SiN or advanced pattern film (APF) which is easy to be removed, so that the dummy spacer **105** can be easily replaced by a low-K spacer.

Furthermore, liner layers **106** are formed respectively at both sides of the gate structure **101** before forming the dummy spacer **105**. The material of the liner layers **106** may include silicon carbonitride (SiCN), silicon oxynitride (SiON), and silicon nitride (SiN). The wet etching rates of those material are quite different from the etching rate of the dummy spacer **106** formed thereon, so that the liner layer **106** may serve as an etching stop layer during the step of removing the dummy spacer **105** because of their high etch selectivity. The presence of the liner layers **106** may further facilitate the adhering of the dummy spacer **105** on the gate structure **101** and substrate **100**.

Please refer to FIG. 2, where epitaxial structures **107** are formed respectively at both sides of the gate structure **101**. The epitaxial structures **107** are formed on the silicon surface at both sides of the gate structure **101** through an epitaxy process. The material of the epitaxial structures **107** may include silicon germanium (SiGe), silicon carbide (SiC), a combination thereof, or other III-V compounds, depending on the type of transistor (like PMOS or NMOS). The steps of forming epitaxial structure **107** may comprise: performing several dry etching processes and/or wet etching processes to form a recess **108** in the substrate **100** at both sides of the gate

structure **101**. Since the above etching process has dominant etching rate along specific crystallographic orientation of substrate material, the resulting recess **108** will have specific cross-sectional shape, such as the diamond shape shown in FIG. 2. Subsequently, perform a selective epitaxy growth (SEG) process to grow epitaxial structure **107** in the recess **108**. Since the recess **108** has diamond cross-sectional shape and the epitaxial structure **107** will always grow along the surface of the substrate **100**, the cross-sectional shape of resulting epitaxial structure **107** will also be diamond shape, whose top surfaces are higher than the surface of the substrate **100**. The formed epitaxial structures **107** may exert a stress on the lattice of the substrate **100** under the gate structure **101** because of different lattice constant between epitaxial structures **107** and substrate **100** (usually Si Substrate), thereby forming a strained silicon channel, wherein electrons or holes mobility will be increased. In addition, the epitaxial structures **107** may include an un-doped epitaxial layer, a doped epitaxial bulk, and an un-doped epitaxial cap layer.

After forming the epitaxial structures **107**, an ion implantation process is subsequently performed on the epitaxial structure **107** formed in the previous steps. This process may implant n-type dopants (ex. P, As, or Sb), p-type dopants (ex. B or BF₂) combined with other common dopants (ex. C, N, F, Ge, or Si) into the epitaxial structure **107** in corresponding NMOS or PMOS regions, thereby defining a source **107a** and a drain **107b** in the epitaxial structure **107** at both sides of the gate structure **101**.

Optionally, a self-aligned Salicidation process may be performed to form a salicide layer (not shown) conformably on the surface of the epitaxial structures **107** for facilitating the electrical connection with the contact plug (not shown) formed in following process, wherein the salicide process may include a post clean process, a metal depositing process, an annealing process, or a selective etching process, etc. The forming process of the salicide layer is well-known in the art, thus no unnecessary detail is given herein for simplicity. Alternatively, the above-mentioned salicide process may be performed after the following replacement metal gate process, or after the formation of inter-layer dielectric (ILD) covering on source **107a** and drain **107b**, or after the formation of contact holes.

Alternatively, in another embodiment of present invention, epitaxial structure **107** may be formed directly on the source **107a** and drain **107b** in substrate **100**, as the aspect of raised source/drain shown in FIG. 3, without forming the recess **108**. In this embodiment, the epitaxial structure **107** is formed conformably on the surface of substrate **100**, while the source **107a** and drain **107b** are defined in substrate **100** under the epitaxial structure **107**.

After defining the source **107a** and drain **107b**, please refer to FIGS. 2 and 4, a replacement metal gate (RMG) process is performed to replace the dummy gate **103** with metal gate. The replacement metal gate process is an advantageous process, which is able to avoid processes of high thermal budget due to the tempering treatment for activating the source/drain ultra-shallow junction and to provide wider material choices. The steps of replacement metal gate process in present invention may comprise: blanket-depositing a ILD layer **109** on entire substrate **100** (including entire gate structure **101** and epitaxial structure **107**); removing parts of the ILD layer **109** and of the cap layer **104** by a planarization process to expose the dummy gate **103** in the gate structure **101**; performing an etching process is to etch the exposed dummy gate **103**. The dummy gate **103** and gate oxide layer **102** is then completely

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removed in this step to expose the substrate **100** thereunder. A gate trench **110** is formed in this process to provide a space for the metal gate material.

Please refer to FIG. **5**, taken the high-K last process for example, a deposition process is performed first to form a gate dielectric layer **111** in the gate trench **110** after forming the gate trench **110**. The gate dielectric layer **111** may include high-K materials with dielectric constant larger than 4, such as rare earth metal oxides or lanthanide series metal oxides. The material may be selected from the group consisting of hafnium oxide (HfO_2), hafnium silicon oxide (HfSiO_4), hafnium silicon oxynitride (HfSiON), aluminum oxide (Al_2O_3), lanthanum oxide (La_2O_3), tantalum oxide (Ta_2O_5), yttrium oxide (Y_2O_3), zirconium oxide (ZrO_2), strontium titanate oxide (SrTiO_3), zirconium silicon oxide (ZrSiO_4), hafnium zirconium oxide (HfZrO_4), strontium bismuth tantalate, ($\text{SrBi}_2\text{Ta}_2\text{O}_9$, SBT), lead zirconate titanate ($\text{PbZr}_{1-x}\text{Ti}_x\text{O}_3$, PZT), and barium strontium titanate ($\text{Ba}_x\text{Sr}_{1-x}\text{TiO}_3$, BST). The gate dielectric layer **111** may serve as the dielectric layer for the following metal gate structure.

On the other hand, for the high-K first process, the above-mentioned gate oxide layer **102** is formed by high-K material. This gate oxide layer **102** will not be removed in the following step of forming gate trench **110**. The gate oxide layer **102** in this process may serve as the gate oxide layer in replacement metal gate process. It is unnecessary to form additional gate dielectric layer **111**.

Subsequently, please refer again to FIG. **5**, a chemical vapor deposition (CVD), a physical vapor deposition (PVD), or an atomic layer deposition (ALD) is performed to form a work function metal layer (WFM, **112**) in the gate trench **110**. The work function metal layer **112** may be a p-type work function metal layer and exemplarily includes titanium nitride (TiN), tantalum nitride (Ta₂N), titanium carbide (TiC), tantalum carbide (TaC), tungsten carbide (WC), or aluminum titanium nitride (TiAlN), but not limited thereto. Alternatively, the work function metal layer **112** may be an n-type work function metal layer and exemplarily includes titanium aluminide (TiAl), zirconium aluminide (ZrAl), tungsten aluminide (WAl), tantalum aluminide (TaAl), or hafnium aluminide (HfAl), but not limited thereto. In addition, the work function metal layer **112** may be a single-layered structure or a multi-layered structure. For example, the work function metal layer **112** may comprise a plurality of different work function metal layers, to optimize the electrical properties of the gate device.

After the formation of work function metal layer **112**, a top barrier layer (not shown) may be optionally formed in gate trench **110**, and a filling metal layer **113** is then formed thereon. The filling metal layer **113** is formed to fill up the gate trench **110** and serves as the gate electrode. The filling metal layer **113** includes materials with low resistivity and superior gap-filling characteristics, such as Al, W, Cu, TiAl, or titanium aluminum oxide (TiAlO), but not limited thereto.

After forming the gate electrode above, one or more planarization process is finally performed, such as a CMP process, to remove the unnecessary filling metal layer **113**, work function metal layer **112**, and gate dielectric layer **109**, thereby completing the fabrication of a replacement metal gate structure **116**. Please note that the above-described replacement metal gate (RMG) process is only an exemplified embodiment, which briefly explain the basic steps for fabricating the various components in the replacement metal gate structure. Some repeating steps, or necessary components, may be omitted in this description without obscuring the principles of the RMG process combined with the semiconductor process of the present invention.

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Subsequently, please refer to FIG. **5** and FIG. **6**. After the fabrication of metal gate structure **116**, a wet etching process is performed to remove the dummy spacer **105**, so that a recess is formed between the ILD layer **109** and the liner layer **106**. A low-K spacer **114** is then formed in said recess (especially the recess **117** between metal gate **116** and epitaxial structure **107**) by spin-on-glass (SOG) process, for example, by introducing and curing the precursor, such as hydrogen polysiloxane (with K value of approximately 3.5), methyl silsesquioxane (with K value of approximately 2.7), or organo aromatic polymer (with K value of approximately 2.6 to 2.9). Optionally, an ion implant process may be performed after removing the dummy spacer **105** and before forming low-K spacer **114** to form a lightly-doped drains (LDD, not shown) in the substrate **100** under the predetermined position of low-K spacer **114**. The dopants may be n-type dopants such as phosphor (P) or arsenic (As) (for NMOS transistor), or p-type dopants such as boron (B) (for PMOS transistor).

The low-K spacer **114** in present invention may have different aspects. Please refer now to the FIG. **5** and FIG. **7**, the ILD layer **109** may also be removed during the step of removing dummy spacer **105**. This way, a recess **118** is formed between the entire metal gate structure **116** and epitaxial structure. The low-K spacer **114** will be formed respectively in the recesses **118**, and the top surface of low-K spacer **114** will be lower than the top surface of metal gate structure **116**. The bottom portion of the liner **106** is covered by the low-K spacer **114** that has a top surface leveled with the top surface of the epitaxial structure **107**.

In other embodiment of present invention, the liner layer **106** of gate structure may be formed after completing the replacement metal gate process, rather than be formed before the forming of dummy space **105**. Please refer to FIG. **5** and FIG. **8**, in this embodiment, the liner layer **106** is not existed in FIG. **5**. After removing the dummy spacer **105**, a deposition process will be performed first to form a liner layer **106** in the recess between the metal gate structure **116** and ILD layer **109**, and the low-K spacer **114** is formed subsequently in said recess, especially the recess **117** between the metal gate structure **116** and the epitaxial structure **107**. In this way, the low-K spacer **114** will be surrounded by the liner layer **106**. The material of liner layer **106** may include silicon carbonitride (SiCN), silicon oxynitride (SiON), and silicon nitride (SiN).

On the other hand, the replacement metal gate (RMG) process in present invention may also be performed after the formation of low-K spacer **114**, depending on the mechanical strength of the low-K spacer **114**. If the RMG process is performed after the formation of low-K spacer **114**, the forming step of gate trench **110** in FIG. **4** will be pending. That is, the dummy spacer **105** will be replaced first with the low-K spacer **114**, and the replacement process of metal gate is then performed.

According to the above-mentioned process flow, a semiconductor structure with metal gate is provided in present invention, as shown in FIG. **7**, comprising a substrate **100**, a metal gate structure **116** on substrate **100**, epitaxial structures **107** disposed respectively at both sides of the metal gate structure **116**, and low-K spacers **114** disposed respectively in the recesses **118** between the metal gate structure **116** and the epitaxial structures **107**, wherein the top surface of the low-K spacer **114** is lower than the top surface of the metal gate structure **116**.

The above-mentioned process flow of present invention may also be applied to the fabrication of fin field effect transistor (Fin FET). In following embodiments, the process flow for Fin FET in present invention will be explained with reference to FIGS. **9-15**.

First, as shown in FIG. 9, a substrate **200** is provided as the base of the whole semiconductor structure. The substrate **200** may be, but not limited to, a silicon substrate, an epitaxial silicon substrate, a silicon germanium (SiGe) substrate, a silicon carbide (SiC) substrate, or a silicon-on-insulator (SOI) substrate, etc. The substrate **200** may be provided with predetermined NMOS regions and PMOS regions and corresponding P-wells and N-wells. A plurality of protruding fin structures **200a** are formed on the substrate **200**. The fin structure **200a** may be formed by providing a patterned mask layer on the substrate **200** and then using said mask layer as an etch mask to perform an etching process on the substrate **200**. After forming the fin structure **200a**, an isolation structure **200b** (ex. an oxide layer) is subsequently formed between each of the fin structures **200a** by successively performing a deposition, a planarization, and an etch back process. As shown in FIG. 15, the isolation structure **200b** may be formed between each fin structures **200a** parallel to each other, thus good isolation may be provided for the devices formed in following process.

Subsequently, forming a patterned gate structure **201** on the fin structure **200a**, wherein the gate structure **201** may comprise a gate oxide layer (ex. SiO₂ and/or high-K material) **202**, a dummy gate **203** (ex. poly-Si, SiN, SiON, or advanced pattern film (APF)), and a cap layer (ex. SiN or SiO₂) **204**. The forming methods of gate structure **201** are well-known in the art, and are not described herein for simplicity. As shown in FIG. 15, the gate structure **201** is formed traversing on part of the fin structures **200a** and part of the substrate **200** in the direction perpendicular to the fin structures **200a**, thereby forming a tri-gate FET structure or a fin FET structure.

Refer again to FIG. 9, the dummy spacer **205** is formed on at least one surrounding sidewalls of the gate structure **201**. Dummy spacer **205** is formed by depositing a material layer and then performing a dry etching process to said material layer. In present invention, the function of dummy spacer **205** is to isolate the gate structure **201** from the epitaxial structure or source/drain formed in subsequent process. Also, the dummy spacer **205** has higher mechanical strength for accommodating to the following replacement metal gate (RMG) process. The material of dummy spacer **205** may include silicon nitride (SiN) or advanced pattern film (APF) which is easy to be removed, so that the dummy spacer **205** can be easily replaced with low-K spacer.

Furthermore, liner layers **206** may be formed respectively at both sides of the gate structure **201** before forming the dummy spacer **205**. The material of liner layer **206** may include silicon carbonitride (SiCN), silicon oxynitride (SiON), and silicon nitride (SiN). The wet etching rates of those materials are quite different from the etching rate of the dummy spacer **206** formed thereon, thus the liner layer **206** may serve as an etching stop layer in the step of removing dummy spacer **205** because of their high etch selectivity. The presence of liner layer **206** may further facilitate the adhering of dummy spacer **205** on gate structure **201** and fin structure **200a**.

Subsequently, please refer to FIG. 10, epitaxial structures **207** are formed respectively at both sides of the gate structure **201** after the formation of gate structure **201**. Epitaxial structure **207** is formed on the silicon surface at both sides of the gate structure **201** by an epitaxy process. The material of the epitaxial structures **207** may include silicon germanium (SiGe), silicon carbide (SiC), a combination thereof, or other III-V compounds, depending on the type of transistor (such as PMOS or NMOS). The steps of forming gate structure **201** may comprises: performing several dry etching process and/or wet etching process to form a recess **208** in the fin structure

200a at both sides of the gate structure **201**; performing a selective epitaxy growth (SEG) process to grow epitaxial structure **207** in the recess **208**. Since the epitaxial structure **207** always grows along specific crystallographic orientation, the cross-sectional shape of epitaxial structure **207** is polygon, such as hexagon, whose top surface is higher than the surface of the fin structure **200a**. The formed epitaxial structures **207** may exert a stress on the lattice of the fin structure **200a** under the gate structure **201** because of different lattice constant between epitaxial structures **207** and fin structure **200a** (usually made of Si material), thereby forming a strained silicon channel that may further increase the electrons or holes mobility.

After forming the epitaxial structures **207**, an ion implantation process is subsequently performed on the epitaxial structure **207**. This process may implant n-type dopants (ex. P, As, or Sb), p-type dopants (ex. B or BF₃) combining with other common dopants (ex. C, N, F, Ge, or Si) into the epitaxial structure **107** in corresponding NMOS regions or PMOS regions, thereby defining a source **207a** and a drain **207b** in the epitaxial structure **207** at both sides of the gate structure **201**. A transistor structure is, therefore, completed.

Optionally, a self-aligned salicidation process may be performed to form a salicide layer (not shown) conformably on the surface of the epitaxial structures **207** for facilitating the electrical connection with the contact plug (not shown) formed in following process. The forming process of the salicide layer is well-known in the art, thus no unnecessary detail is given herein for simplicity. The above-mentioned salicidation process may also be performed after the replacement metal gate process, or after the formation of inter-layer dielectric (ILD) covering on source **207a** and drain **207b**, or after the formation of contact holes.

Alternatively, in another embodiment of present invention, epitaxial structure **207** may be formed directly on the fin structure **200a**, as the aspect of raised source/drain shown in FIG. 11, without forming any recess **208**. In this embodiment, the epitaxial structure **207** is formed conformably on the surface of fin structure **200a**, while the source **207a** and drain **207b** are defined in part of the epitaxial structure **207** and part of the fin structure **200a**.

After defining the source **207a** and drain **207b**, please refer to FIGS. 10 and 12, a replacement metal gate (RMG) process is performed to replace the dummy gate **203** with a metal gate. The steps of replacement metal gate process in present invention may comprise: blanket-depositing an ILD layer **209** on entire substrate **200** (including gate structure **201**, fin structures **200a**, epitaxial structures **207**, and isolation structure **200b**); removing parts of the ILD layer **209** and of the cap layer **204** by a planarization process to expose the dummy gate **203** in the gate structure **201**; performing an etching process to etch the exposed dummy gate **203**. The dummy gate **203** and gate oxide layer **202** is then completely removed in this step to expose the surface of fin structures **200a** thereunder. A gate trench **210** is formed in this process to provide a space for the metal gate material.

Please refer to FIG. 13, taken the high-K last process for example, a deposition process is performed first to form a gate dielectric layer **211** in the gate trench **210** after forming the gate trench **210**. The gate dielectric layer **211** may includes high-K materials, such as rare earth metal oxides or lanthanide series metal oxides. The material may be selected from the group consisting of hafnium oxide (HfO₂), hafnium silicon oxide (HfSiO₄), hafnium silicon oxynitride (Hf-SiON), aluminum oxide (Al₂O₃), lanthanum oxide (La₂O₃), tantalum oxide (Ta₂O₅), yttrium oxide (Y₂O₃), zirconium oxide (ZrO₂), strontium titanate oxide (SrTiO₃), zirconium

silicon oxide (ZrSiO_4), hafnium zirconium oxide (HfZrO_4), strontium bismuth tantalate, ($\text{SrBi}_2\text{Ta}_2\text{O}_9$, SBT), lead zirconate titanate ($\text{PbZr}_x\text{Ti}_{1-x}\text{O}_3$, PZT), and barium strontium titanate ($\text{Ba}_x\text{Sr}_{1-x}\text{TiO}_3$, BST). The gate dielectric layer **211** may serve as the dielectric layer for the following metal gate structure. Please note that for the high-K first process, the above-mentioned gate oxide layer **202** is formed by high-K material. This gate oxide layer **202** will not be removed in the step of forming gate trench **210**. The gate oxide layer **202** in this process may serve as a gate oxide layer for metal gate. It is unnecessary to form additional gate dielectric layer **211**.

Subsequently, please refer again to FIG. **13**, a chemical vapor deposition (CVD), a physical vapor deposition (PVD), or an atomic layer deposition (ALD) is performed to form a work function metal layer (WFM, **212**) in the gate trench **210**. The work function metal layer **212** may be a p-type work function metal layer and exemplarily includes titanium nitride (TiN), tantalum nitride (TaN), titanium carbide (TiC), tantalum carbide (TaC), tungsten carbide (WC), or aluminum titanium nitride (TiAlN), but not limited to this. Alternatively, the work function metal layer **212** may be an n-type work function metal layer and exemplarily includes titanium aluminide (TiAl), zirconium aluminide (ZrAl), tungsten aluminide (WAl), tantalum aluminide (TaAl), or hafnium aluminide (HfAl), but not limited to this. In addition, the work function metal layer **212** may be a single-layered structure or a multi-layered structure. For example, the work function metal layer **212** may comprises a plurality of different work function metal layers, to optimize the electrical properties of the gate device.

After the formation of work function metal layer **212**, a top barrier layer (not shown) may be optionally formed in gate trench **210**, and a filling metal layer **213** is then formed thereon. The filling metal layer **213** is formed to fill up the gate trench **210** and serves as the gate electrode. The filling metal layer **213** includes materials with low resistivity and superior gap-filling characteristics, such as Al, W, Cu, TiAl, or titanium aluminum oxide (TiAlO), but not limited thereto.

After forming the gate electrode above, one or more planarization process is finally performed, such as a CMP process, to remove the unnecessary filling metal layer **213**, work function metal layer **212**, and gate dielectric layer **211** formed on the ILD layer **209**, thereby completing the fabrication of a metal gate structure **216**. Please note that the above-described replacement metal gate (RMG) process is only an exemplified embodiment, which briefly explain the basic steps for fabricating the various components in the replacement metal gate structure. Some repeating steps, or necessary components, may be omitted in this description without obscuring the principles of the RMG process combined with the semiconductor process of the present invention.

Similarly, an ion implant process may be performed to form lightly doped drains (LDD, not shown) in the fin structure **200a** under the spacers **205**. The dopants may be n-type dopants such as phosphor (P) or arsenic (As) (for NMOS transistor), or p-type dopants such as boron (B) (for PMOS transistor).

Subsequently, please refer to FIG. **13** and FIG. **14**. After the fabrication of metal gate structure **116**, a wet etching process is performed to remove the dummy spacer **205** and ILD layer **209**, thereby exposing the metal gate structure **216**, the epitaxial structures **207**, and the isolation structure **200b**. A low-K material layer (not shown) is then formed on entire substrate (including the region of metal gate structure **216**, epitaxial structure **207**, and isolation structure **200b**) by spin-on-glass (SOG) process, for example, by introducing and curing the precursor, such as hydrogen polysiloxane (with K

value of approximately 3.5), methyl silsesquioxane (with K value of approximately 2.7), or organo aromatic polymer (with K value of approximately 2.6 to 2.9). After forming said low-K material layer, an etch back process is performed to reduce the thickness of the deposited low-K material layer to a predetermined value. The low-K spacer **214** is, therefore, formed. More specifically, as shown in FIG. **14** and FIG. **15**, the low-K spacer **214** formed in present embodiment fill up the recess **217** between the gate structure **216** and epitaxial structure **207** and the spaces between each fin structures **200a**. Furthermore, the surface of the low-K spacer **214** is leveled with the top surface of the epitaxial structure **207** or is lower than the top surface of the metal gate structure **216**.

On the other hand, the replacement metal gate (RMG) process in present invention may also be performed after the formation of low-K spacer **214**, depending on the mechanical strength of the low-K spacer **214**. If the RMG process is performed after the formation of low-K spacer **214**, the forming step of gate trench **210** in FIG. **12** will be pending. In this process flow, the replacement process of metal gate will be performed after removal of the dummy spacer **205** and ILD layer **209** and the formation of the low-K material layer.

According to the above-mentioned process flow, as shown in FIG. **14**, a fin field effect transistor (Fin FET) is provided in present invention comprising: a substrate **200**; at least one fin structure **200a** formed on substrate **200**; a gate **216** formed on fin structure **200a**; epitaxial structures **207** formed respectively in fin structure **200a** at both sides of the gate **216**; and low-K spacers **214** formed respectively in the recesses **217** between gate **216** and epitaxial structures **207** and in the recesses surrounding or between the fin structures **200a**, wherein the top surface of low-K spacer **214** is leveled with the top surface of epitaxial structure **207** and is lower than the top surface of the gate **216**, but higher than the top surface of the fin structure **200a**.

For present invention, it is possible to form a spacer with low-K material by using spin-on-glass (SOG) process. The parasite capacitance may be efficiently reduced by forming the spacer structure with such low-K material. Moreover, the recess between the gate structure and the epitaxial structures may be filled completely with the spacer in this process due to its excellent gap-filling capacity.

To sum up the processes and all technical features provided in the above embodiments of the present invention, a process flow of present invention is provided in FIG. **16** comprising the steps of: providing a substrate or a substrate with fin structures (step **300**), forming a gate structure on said substrate or said substrate with fin structures (step **301**), forming dummy spacers on the sidewalls of said substrate (step **302**), forming epitaxial structures on said substrate or on said fin structures (step **303**), performing a replacement metal gate process (step **304**), removing said dummy spacers (step **305**), and forming low-K spacers (step **306**), wherein the replacement metal gate process (step **304**) may also be performed after the formation of the low-K spacers (step **306**).

Those skilled in the art will readily observe that numerous modifications and alterations of the device and method may be made while retaining the teachings of the invention. Accordingly, the above disclosure should be construed as limited only by the metes and bounds of the appended claims.

What is claimed is:

1. A fin field effect transistor (Fin FET), comprising:
 - a substrate;
 - at least one fin structure formed on said substrate;
 - a gate formed on said at least one fin structure;
 - epitaxial structures formed respectively in said at least one fin structure at both sides of said gate; and

low-K spacers, a portion of the low-k spacers filling up at least one recess between said gate and said epitaxial structures and another portion of the low-k spacers filling up at least one recess surrounding said at least one fin structure,

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wherein a top surface of the portion of the low-k spacers filling up the at least one recess between said gate and said epitaxial structures and a top surface of the another portion of said low-K spacers filling up the at least one recess surrounding said at least one fin structure are leveled with a top surface of said epitaxial structures, higher than a top surface of the at least one fin structure, and lower than a top surface of the gate.

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2. The fin field effect transistor according to claim 1, further comprising a liner layer formed between said gate and said epitaxial structures.

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3. The fin field effect transistor according to claim 2, wherein a material of said liner layer comprises silicon carbonitride (SiCN), silicon oxynitride (SiON), or silicon nitride (SiN).

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4. The fin field effect transistor according to claim 1, wherein said epitaxial structures comprise at least one source and at least one drain.

5. The fin field effect transistor according to claim 1, wherein a material of said epitaxial structures comprises Si—Ge epitaxy or Si—C epitaxy.

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6. The fin field effect transistor according to claim 1, wherein said gate comprises a poly-Si gate or a metal gate.

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